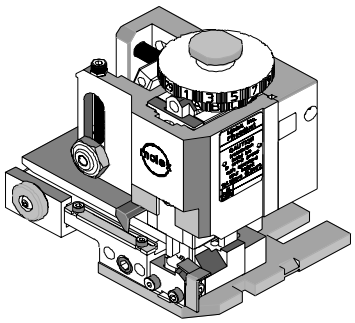
FineAdjust Applicator Specification Sheet Part No. 63867-1000



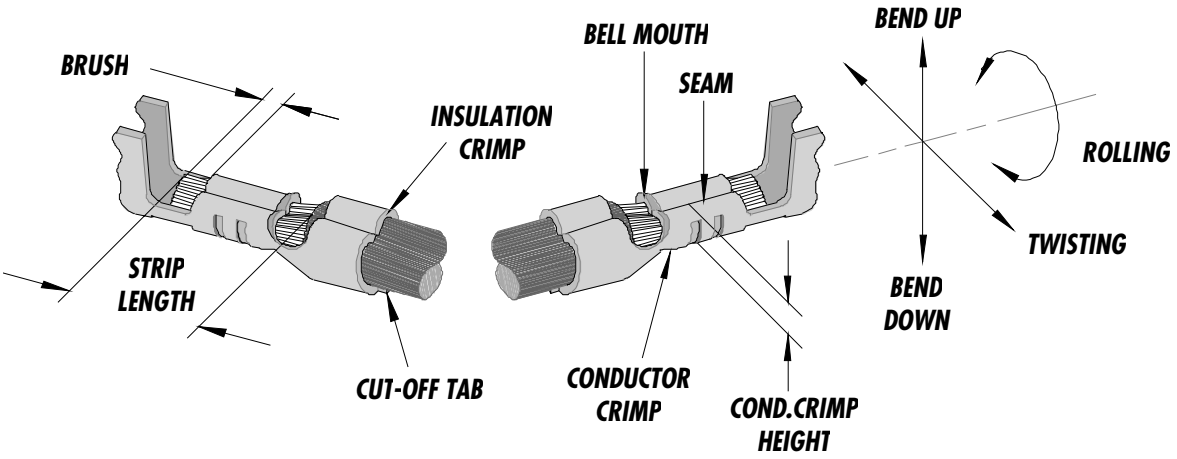
FEATURES

- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry standard mounting and shut height 135.80mm (5.346")
- Quick set-up time; plus the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.15mm (.0006") for conductor crimp height and .063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other
- Directly adapts to most automatic wire processing machines

SCOPE

Terminal Series No.	Wire Size		Insulation Diameter		Strip Length	
	AWG	mm^2	mm	In.	mm	In.
94539-1000	20-24	0.50-0.25	2.20 Max.	.087 Max.	4.10-4.60	.161-.181

DEFINITION OF TERMS



The above terminal drawing is a generic terminal representation. It is not an image of a terminal listed in the scope.

CRIMP SPECIFICATION

Terminal Series No.	Bell mouth		Cut-off Tab Max.		Conductor Brush	
	mm	In.	mm	In.	mm	In.
94539-1000	.20 - .30	.008 - .012	.30	.012	.50 – 1.00	.020 - .040

Terminal Series No.	Bend up Bend down		Twist Roll		Punch Width mm (Ref)				Seam
	Degree		Degree		Conductor		Insulation		Seam shall not be open and no wire allowed out of the crimping area
					mm	In	mm	In	
94539-1000	3	3	4	8	1.42	.056	2.40	.094	

After crimping, the conductor profile should measure the following.

Terminal Series No.	Wire Size		Conductor				Insulation				Pull Force Min.	
			Crimp Height		Crimp Width (Ref)		Crimp Height		Crimp Width (Ref)			
	AWG	mm^2	mm	In.	mm	In.	mm	In.	mm	In.	N	Lb.
94539-1000	20	0.50	0.91-1.01	.036-.040	1.50 Max.	.059 Max.	1.70-1.80	.067-.071	2.45 Max.	.096 Max.	58.8	13.22
94539-1000	22	0.35	0.90-0.98	.035-.039	1.50 Max.	.059 Max.	1.55-1.65	.061-.065	2.45 Max.	.096 Max.	39.2	8.81
94539-1000	24	0.25	0.88-0.96	.035-.038	1.50 Max.	.059 Max.	1.50-1.60	.059-.063	2.45 Max.	.096 Max.	29.4	6.61

Pull Force should be measured with no influence from the insulation crimp.

The above specifications are guidelines to an optimum crimp.

PARTS LIST

Item	Order No	Engineering No.	Description	Quantity
	63867-1000	63867-1000	FineAdjust Applicator (Fig. 1)	REF
1	63457-0024	63457-0024	Conductor Punch	1 Y
2	63455-0026	63455-0026	Conductor Anvil	1 Y
3	63454-0036	63454-0036	Insulation Punch	1 Y
4	63456-0032	63456-0032	Insulation Anvil	1 Y
5	63443-0002	63443-0002	Cut-Off Plunger	1 Y
6	63443-0012	634430012	Front Plunger Retainer	1 Y
7	11-24-1067	4996-4	Cut-Off Plunger Spring	1
8	11-40-4039	8302-5	Front Plunger Striker	1
9	63443-0021	63443-0021	Lower Tooling Key	1
10	63443-6005	63443-6005	Rear Cover	1
11	11-18-4083	60707-8	Front Cover	1
12	63443-2515	63443-2515	Anvil Mount	1
13	63443-4025	63443-4025	Wire Stop	1
14	63443-0009	63443-0009	Scrap Chute	1
15	63800-4900	63800-4900	FineAdjust Applicator	1
16	N/A	N/A	M3 by 6Lg. SHCS	2**
17	N/A	N/A	M4 by 6Lg. SHCS	1**
18	N/A	N/A	M4 by 12Lg. BHCS	2**
19	N/A	N/A	M4 by 16Lg. SHCS	1**
20	N/A	N/A	M4 by 50Lg. SHCS	2**
21	N/A	N/A	3MM by 6Lg. Roll Pin	1**
22	N/A	N/A	#10-32 by 1/4"Lg. BHCS	1**
	63867-1070	63867-1070	Tool Kit (All Y Items)	REF

** The following purchased parts are available from an Industrial supply company such as MSC (1-800-645-7270).

Assembly Drawing

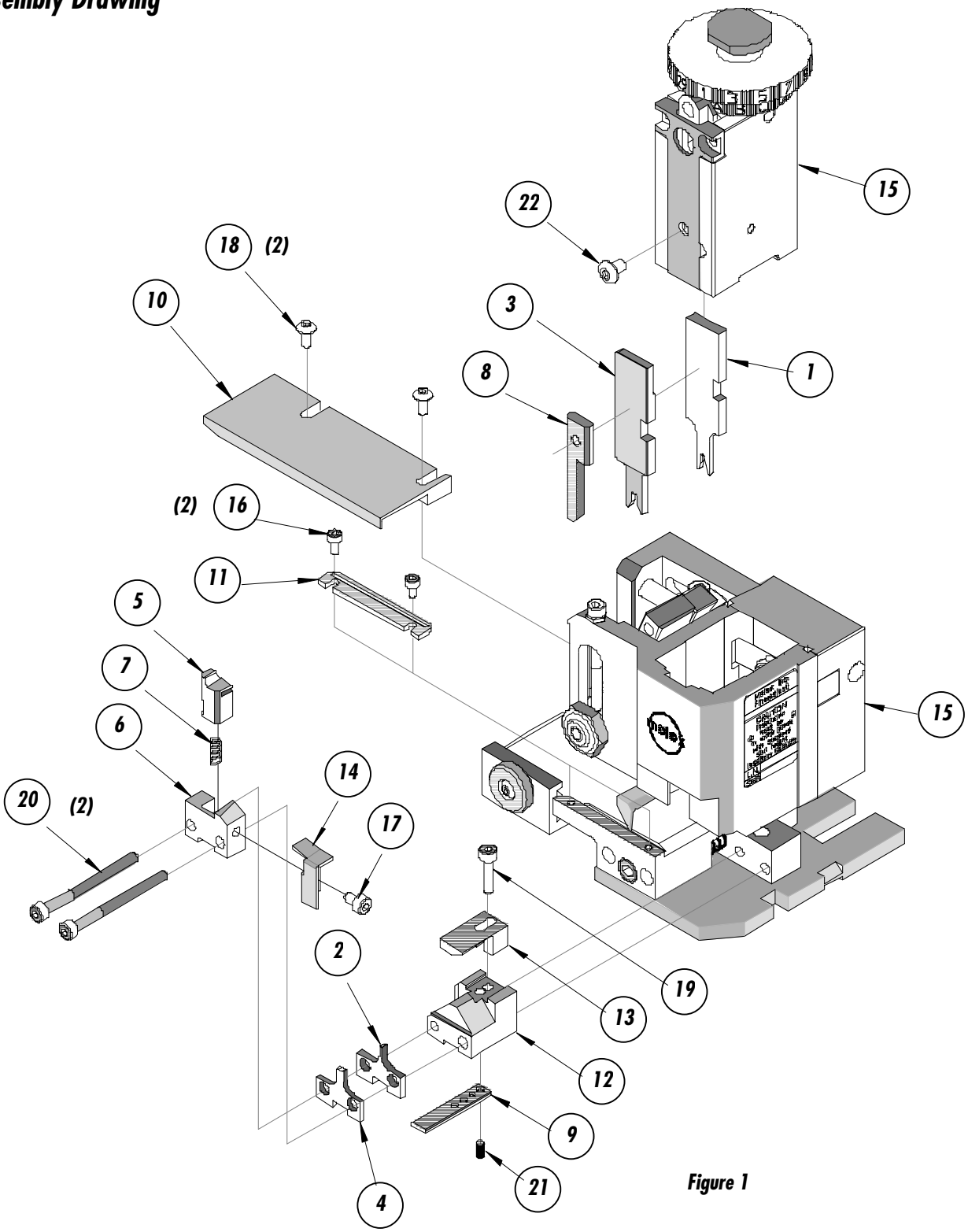


Figure 1

NOTES

1. Molex recommends an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press and Applicator before crimping under power. Check that all screws are tight.
3. Slugs, Terminals, Dirt and Oil should be kept clear of work area.
4. Wear safety glasses at all times.
5. For recommended maintenance refer to the FineAdjust Manual.

CAUTION: This applicator should only be used in a press with a shut height of 135.8 mm (5.346"). Tooling damage could result at a lower setting.

CAUTION: To prevent injury never operate this Applicator without the guards supplied with the press or wire-processing machine in place. Reference the press or wire processing manufacturer's instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

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Visit our Web site at http://www.molex.com